

Date: Monday, 4/23/2007 1:52:37 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE	
Job Number	: 31993		Part Number	: D353541	
Estimate Number	: 12728		Drawing Number	: D3535 UNDER REVIEW	
P.O. Number	: <i>N/A</i>		Project Number	: N/A	
This Issue	: 4/23/2007 S.O. No. : <i>N/A</i>		Drawing Revision	: <i>A B PH 07-04-36</i>	
Prsht Rev.	: NC		Material	: <i>N/A</i>	
First Issue	: <i>MA</i>		Due Date	: 4/30/2007	
Previous Run	: <i>N/A</i>		Qty:	20 Um: Each	
Written By	:				
Checked & Approved By	:				
Comment	: Est RevA New Issue 07-02-15 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S20GA	304/316 .040 Sheet	
		Comment: Qty.: 0.5355 sf(s)/Unit Total : 10.7100 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: <i>M101873</i>	<i>SAD 07/04/20</i>
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: <i>B</i> Prog Rev: <i>B</i> 2-Deburr if necessary	<i>SAD 07/04/30 (26)</i> <i>SAD 07/05/01 (26)</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>SAD 07/04/30 (26)</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>Mo 7/04/30 (26)</i>
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Deburr if necessary <i>→ SAD 07/05/01 (26)</i> Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. Identify as D3535-41 Form Joggle on brake using Jig DT8158 as per Dwg D3535	<i>SBS 07/04/30 (26)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31993

Part Number: D353541

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1107/05/02 26

7.0 POWDER COATING

POWDER COATING



M101601

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

11

07-05-03

26

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-f 07/05/04

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP 15

m-f 07/05/04

26

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1107/05/04

Job Completion



U 07/05/04

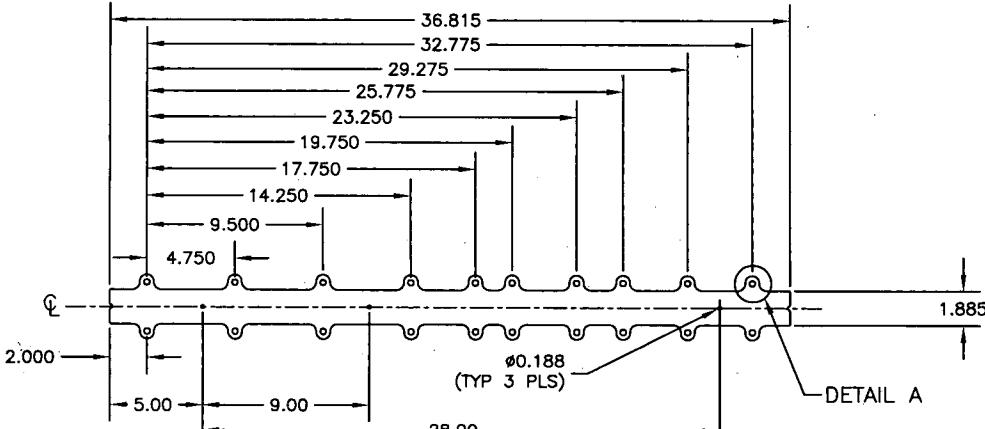
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

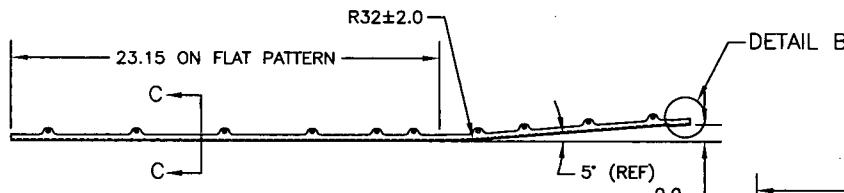
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

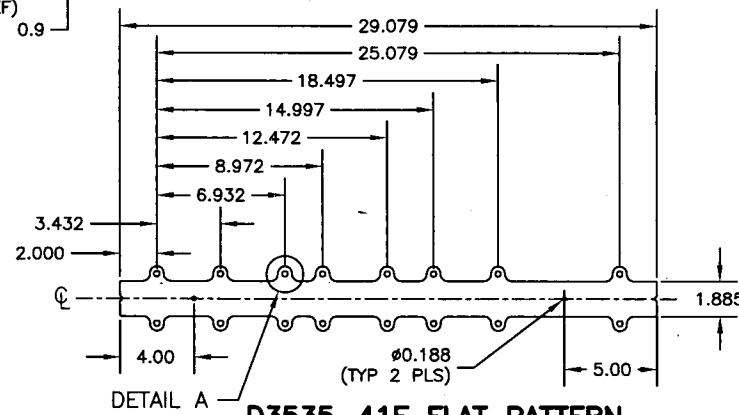
PRELIMINARY ISSUE



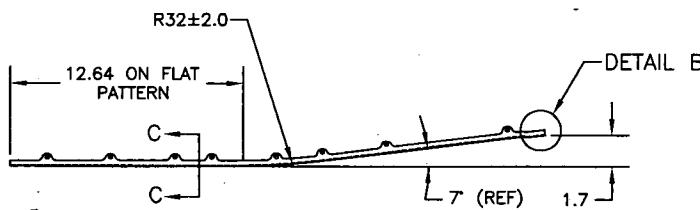
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:10

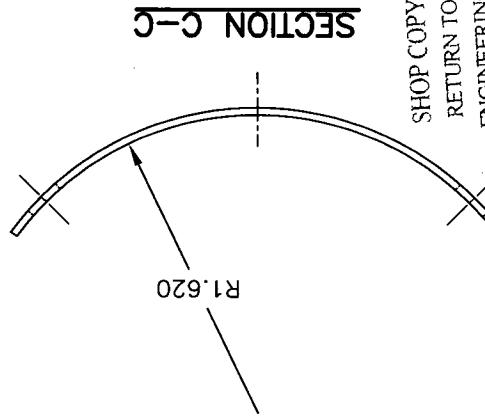
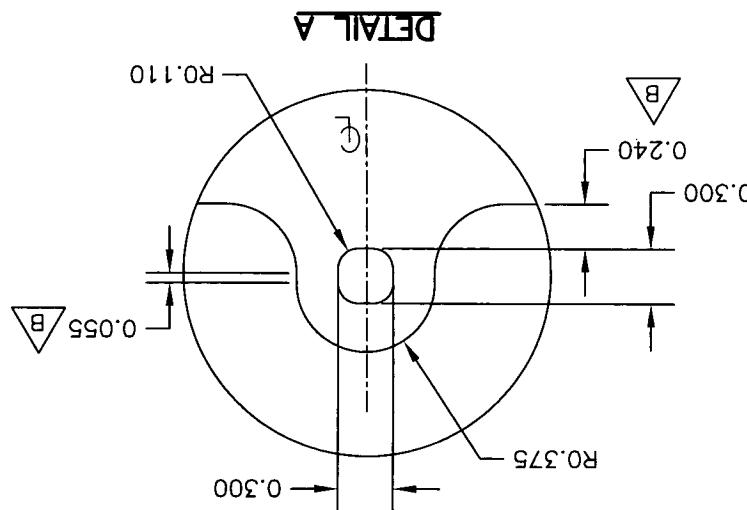
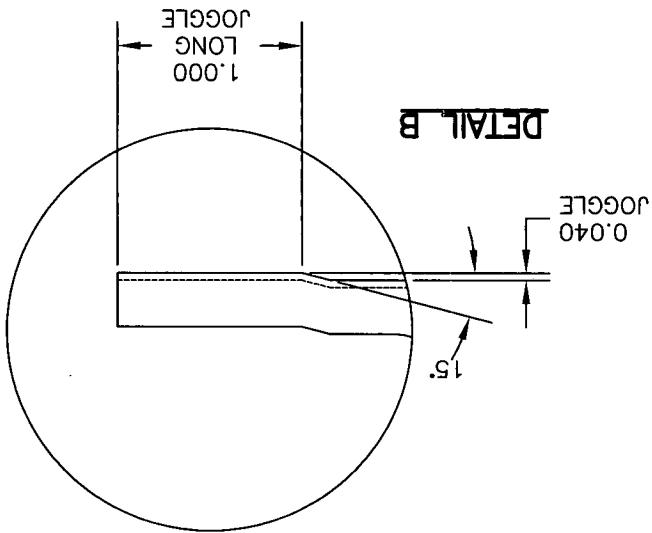
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WORK ORDER
NO. 31993

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	PH	DART AEROSPACE USA, INC.
			PORT HADLOCK, WA
CHECKED	APPROVED		REV. B
			SHEET 7 OF 7
DATE			SCALE
07.04.17			1:1

PRIMARY ISSUE



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DART AEROSPACE LTD

Work Order: 31993

Description: Wear Plate

Part Number: D353541

Inspection Dwg: D3535 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 4.00	+/- 0.030	4.011	✓		Vern	
B Ø0.188	+ 0.005 - 0.001	0.190	✓		Vern	Vertical
C 5.00	+/- 0.030	5.006	✓		Vern	
D 1.885	+/- 0.010	1.887	✓		Vern	
E 29.079	+/- 0.010	29.079	✓		M-T	
F 25.079	+/- 0.010	25.079	✓		Vern M-T	
G 18.497	+/- 0.010	18.500	✓		M-T	
H 14.997	+/- 0.010	15.000	✓		M-T	
I 12.472	+/- 0.010	12.475	✓		M-T / vern	
J 8.972	+/- 0.010	8.971	✓		Vern	
K 6.932	+/- 0.010	6.934	✓		Vern	
L 3.432	+/- 0.010	3.433	✓		Vern	
M 2.000	+/- 0.010	2.006	✓		Vertical vern	
N 0.300	+/- 0.010	0.299	✓		Vern	
O 0.300	+/- 0.010	0.300	✓		Vern	
P 0.038	+/- 0.010	0.038	✓		Vern	
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD
Date: 07/04/30

Audited by: 
Date: 07/04/30

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

